

Date: Wednesday, 19/11/2008 9:58:17 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOOR ASSEMBLY
Job Number	: 43540		
Estimate Number	: 10713		
P.O. Number	:	Part Number	: D3213041
This Issue	: 19/11/2008 S.O. No. :	Drawing Number	: D3213 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: A
Previous Run	: 42027	Material	:
Written By	:	Due Date	: 26/11/2008 Qty: 10 Um: Each
Checked & Approved By	: <u>JUD 08-11-17</u>		
Comment	: Est Rev:A New Issue 05-11-17 17:27		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D31613	Hinge 15.0"
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Assembly Kit

Qty	Part Number	Description	Batch
2	D3161-3	Hinge	B 43551

FF 08/12/09

(10)

2.0	D32131	Door Panel
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Assembly Kit

Qty	Part Number	Description	Batch
1	D3213-1	Door	B42104 x6 B43553 x4

SS 08/12/08

3.0	D32133	Door Panel
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Assembly Kit

Qty	Part Number	Description	Batch
1	D3213-3	Door	B42105 x10 B43553 x4

SS 08/12/08

4.0	MS20470AD44	Rivet, Universal Head
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Comment: Qty.: 24.0000 Each(s)/Unit Total : 240.0000 Each(s)

Pick: Assembly Kit

Qty	Part Number	Description	Batch
24	MS20470AD4-4	Rivet	M09545

SS 08/12/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 19/11/2008 9:58:17 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 43540

Part Number: D3213041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D3213 Identify as D3213-041

FF 08/12/15

(10)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/12/15 (10)

7.0

POWDER COATING

POWDER COATING



M 105642



(10X)

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

12 = 50
322 05
1 = 20

M-1 08/12/15

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-12-15

(X10)

9.0

D2137

Decal - No Step



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description

Batch

1 D2137 Decal

B43312 X9 / B43594X1

FF 08/12/16

(10)

10.0

D2419

Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description

Batch

1 D2419 Handle

B42100 X5 / B43549X5

FF 08/12/16

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 19/11/2008 9:58:17 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 43540

Part Number: D3213041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

D2462

Seal



Comment: Qty.: 2.4000 f(s)/Unit Total : 24.0000 f(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2462

Seal

B 37747

FF 08/12/16

(10)

12.0

D27281

Dart Logo Label - small



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2728-1

Decal

B 39102

FF 08/12/16

(10)

13.0

AN960JD6

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 AN960JD6 Washer

6005

FF 08/12/16

(10)

14.0

MS20470AD46

Rivet, Universal Head



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 MS20470AD4-6

Rivet

109371

FF 08/12/16

(10)

15.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3213

FF 08/12/16

(10)

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/12/16 (210)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

08/12/16 (10)

18.0

QC21

FINAL INSPECTION/W/O RELEASE



08/12/16 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 08.12.16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

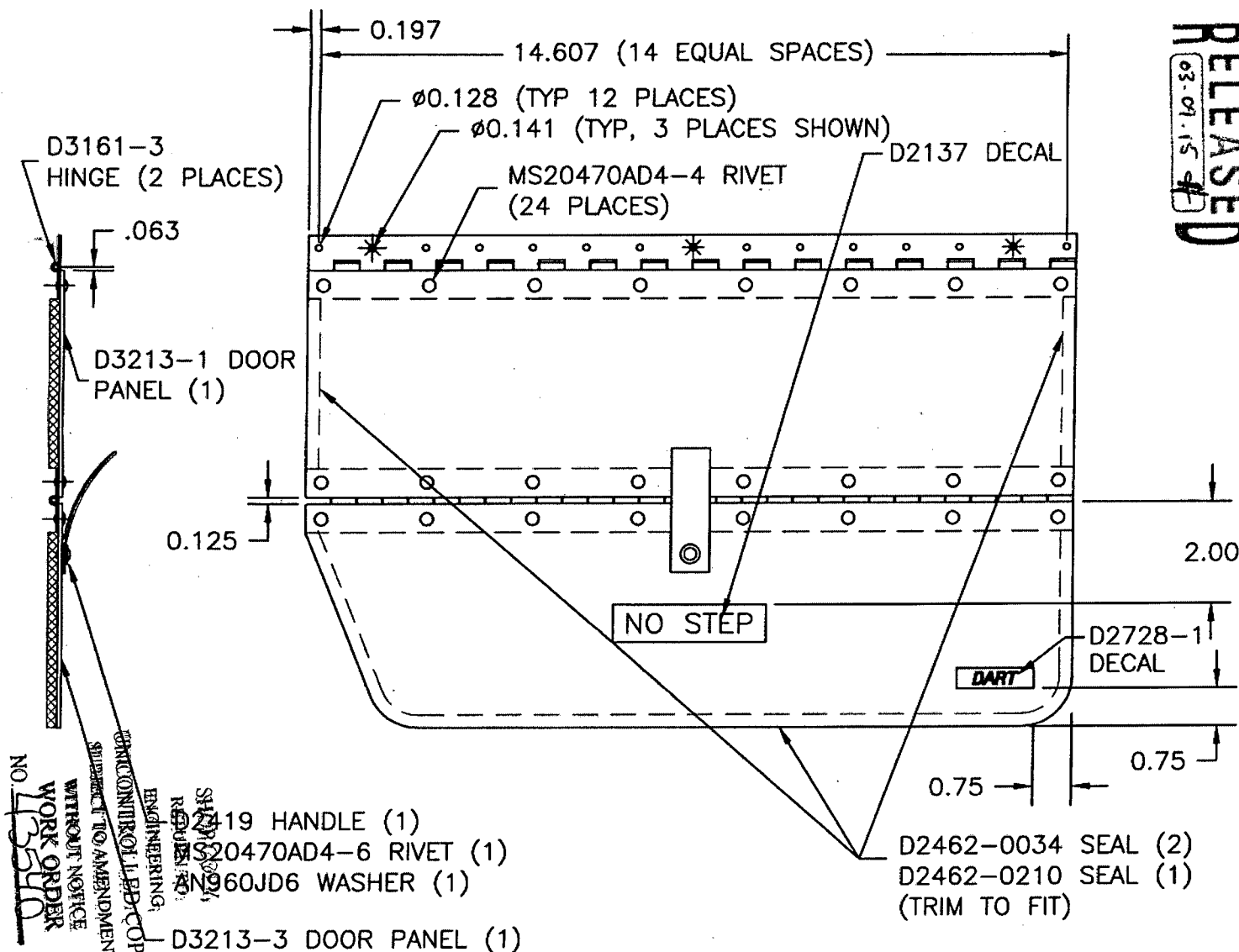
NOTE: Date & initial all entries

DART



DESIGN	CH	DRAWN BY	CH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D3213
DATE	03.09.03	TITLE	DOOR ASSEMBLY	REV. A 1 OF 2
A	03.09.03	NEW ISSUE		SCALE 1:3

RELEASED
03-01-15-47



D3213-041 DOOR ASSEMBLY

FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE

FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3

INSTALL D2137 DECAL, D2419 HANDLE, AND D2462 SEAL AFTER POWDER COAT

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

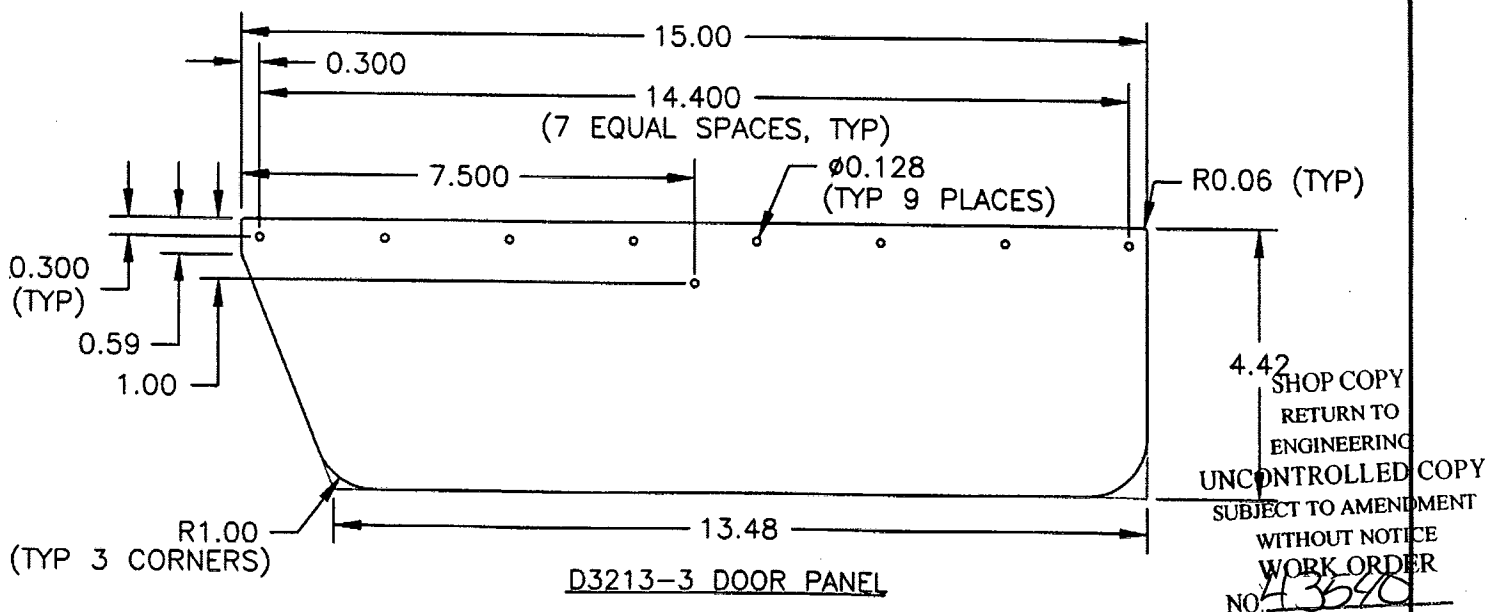
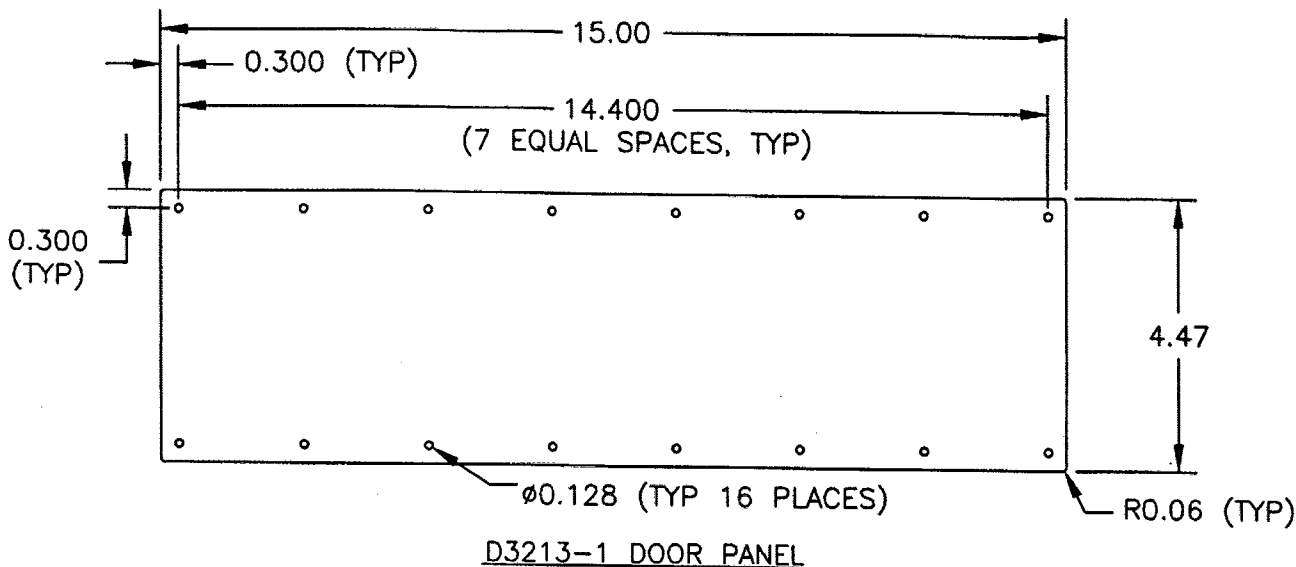
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WORK ORDER
NO. 43510

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DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3213	REV. A 2 OF 2
DATE 03.09.03		TITLE DOOR ASSEMBLY	SCALE 1:3



D3213-1 AND D3213-3

MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
03.09.15

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